

Work Order ID 62366

Page 1

Tuesday, September 28, 2010 11:48:10 AM

Item ID: PB67-43001-15

Accept



Setup Start



Revision ID:

Item Name: Fwf Adjustable Blade Support Assembly

Stop



Start Date: 9/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *Mf*

Date: 10-9-28 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-15	Rev C

100 0.00

Large Fab

Large Fab Memo 0.00

Large Fab Memo 0.00
1- make a 0.090" chamfer in the 1.00" hole before welding
2- assemble parts and weld as per dwg

Pl 10.10.05 -1 -8

110 *OK B* QC9- Inspect visual per QSI004 Fusion Welds 0.00

PD 10.10.05

QC Memo 0.00

Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00

N/A
0.00

QC Memo 0.00

Quality Control

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Process Plan:

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Tooling:

Date:

Run Start



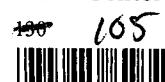
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

10.10.05

Large Fab

0.00

10.10.05

1 8

Small Fab

Memo

0.00

Small Fab

1- grind weld flush in area of PB67-43001-249 only

2- install helicoll insert as per dwg

140



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

- 8/10/06

(TV)

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

N/A

0.00

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

Operation
Description

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

M 18144

Memo

Set Up/
Run Hours

0.00

PL 10-10-6

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/10/11

1

P

180



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- match drill cover to existing holes in support 2- assemble as per dwg

PL 10-10-14

1

P

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Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC5- Inspect part completeness to step on W/O

0.00

8/10/10/14

QC

Quality Control

Memo

0.00

200

Identify as per dwg & Stock Location: WTF

0.00

8/10/10/14

Packaging

Packaging

Memo

0.00

1 8

210



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/10/15 JF

MF
10-10-14

Picklist Print

Tuesday, September 28, 2010 11:48:10 AM

Page 1

Work Order ID: 62366



Parent Item: PB67-43001-15



Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780 		Purchased	No			180	Each	142.0000	1	1		<i>10.10.05</i>	

HELICAL INSERT

Location	Loc Qty	Loc Code
ST314	142	
111064	142	

MS27039-1-10



Purchased

No

Location	Loc Qty	Loc Code
180	Each	117.0000

Screw

Location	Loc Qty	Loc Code
ST291	117	
112794	17	
112940	100	

NAS1149D0316J / AN9603D0LL



Purchased

No

Location	Loc Qty	Loc Code
180	Each	0.0000

Washer

NAS1149D0363J



Purchased

No

Location	Loc Qty	Loc Code
180	Each	2,907.000

Washer

Location	Loc Qty	Loc Code
ST298	2907	
114292	114	
114884	41	
115107	27	
115622	2716	
9221	9	

Picklist Print

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Work Order ID: 62366



Parent Item: PB67-43001-15



Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-249



Manufactured

No

100

Each

11.0000

1

1

10.10.05

Inner Tube Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST438	11	
-------	----	--

	11	
--	----	--

PB67-43001-253



Manufactured

No

52480

100

Each

4.0000

1

1

10.10.05

Gusset

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST438	4	
-------	---	--

	4	
--	---	--

PB67-43001-254



Manufactured

No

44983

100

Each

24.0000

1

1

10.10.05

Gusset

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST438	24	
-------	----	--

	24	
--	----	--

PB67-43001-257



Manufactured

No

52481

100

Each

1.0000

1

1

10.10.05

Inner Tube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST270	1	
-------	---	--

	1	
--	---	--

PB67-43001-71



Manufactured

No

130

Each

3.0000

1

1

10.10.05

PB67-43001-71

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST437A	3	
--------	---	--

	3	
--	---	--

41512

10.10.05

Picklist Print

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Work Order ID: 62366



Parent Item: PB67-43001-15



Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-73

Manufactured No

180

Each

2.0000

1

1

20 Degree Cover Plate



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST445	2	
-------	---	--

41513

2

PB67-43001-83

Manufactured No

180

Each

6.0000

1

1

PB67-43001-83

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

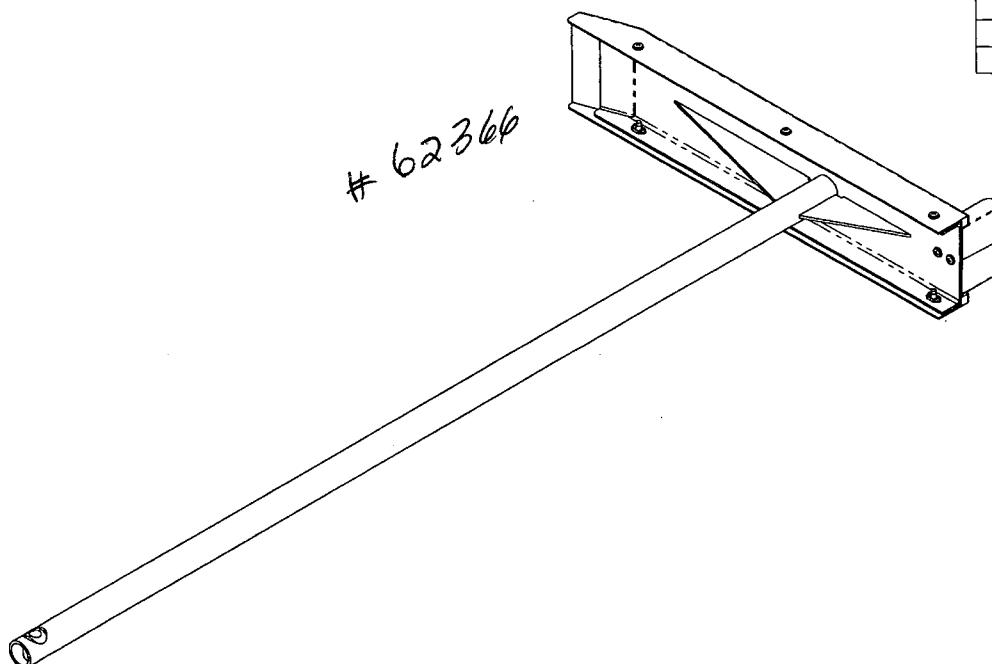
ST445	6	
-------	---	--

52418

6

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20° COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER



RELEASED
R 2010-09-16
[Handwritten signature]

B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND CSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>	DRAWING NO. B67-43001-15 REV. C SHEET 1 OF 2		
CHECKED	<i>[Signature]</i>	MFG. APPR.		
APPROVED	<i>[Signature]</i>	TITLE FWD ADJUSTABLE BLADE SUPPORT ASSY NTS		
DE APPR.	N/A	SCALE		
DATE	10.04.28			

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

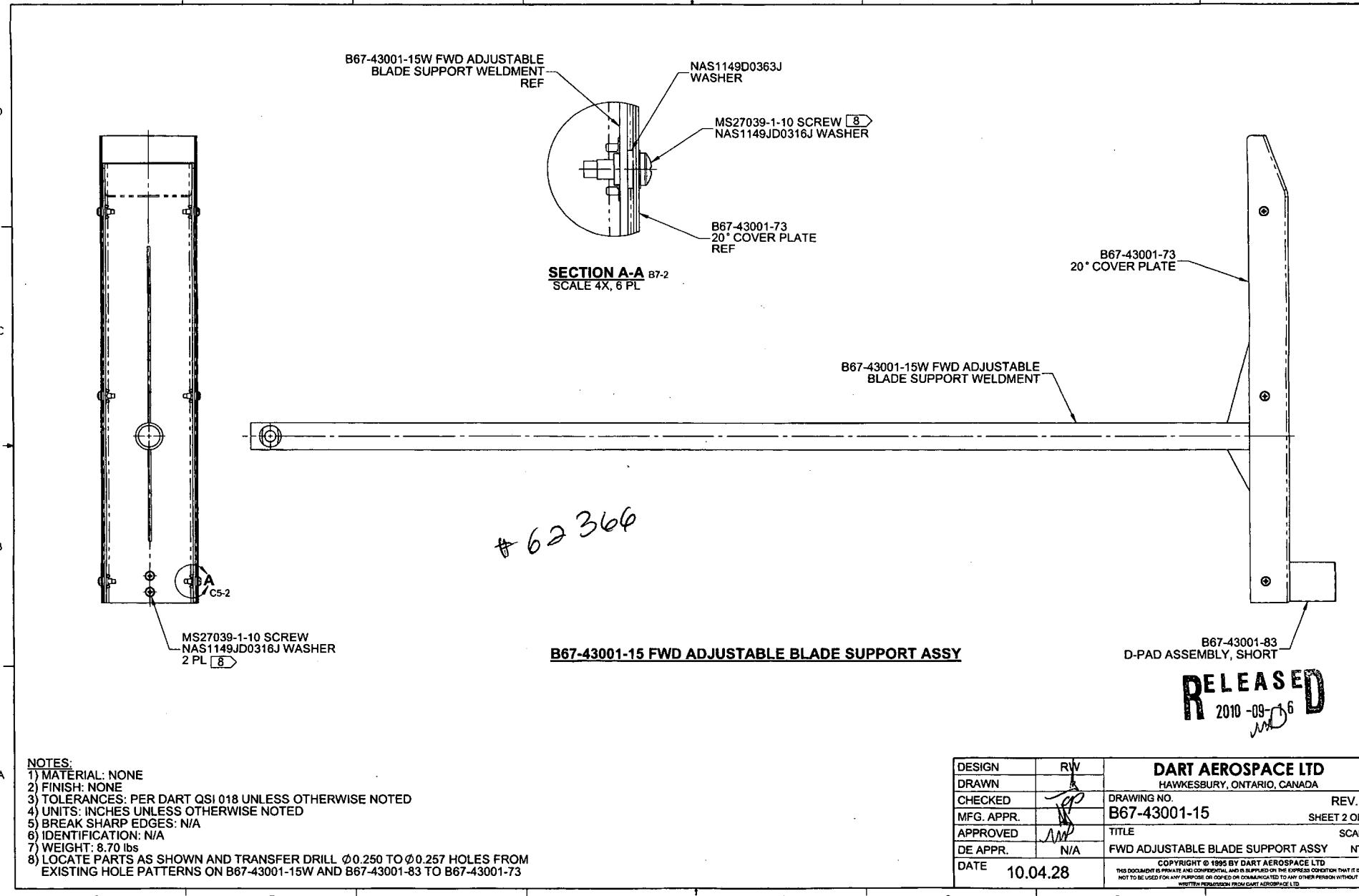
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	[initials]	DRAWING NO. B67-43001-15
CHECKED	[initials]	REV. C
MFG. APPR.	[initials]	SHEET 2 OF 2
APPROVED	[initials]	TITLE
DE APPR.	N/A	SCALE
DATE	10.04.28	FWD ADJUSTABLE BLADE SUPPORT ASSY NTS

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8 7 6 5 4 3 2 1

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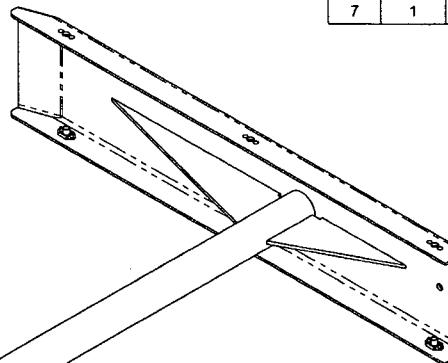
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -15W	P/N	DESCRIPTION
1	X	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-257	INNER TUBE
7	1	MS124780	HELICAL INSERT

62360



B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16
MM

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.			MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. C
DRAWN					
CHECKED		DRAWING NO.	B67-43001-15W		SHEET 1 OF 2
MFG. APPR.		TITLE	FWD ADJUSTABLE BLADE SUPPORT WELDMENT		SCALE
APPROVED		DATE	10.04.28		NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER EXPORT CONTROL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1

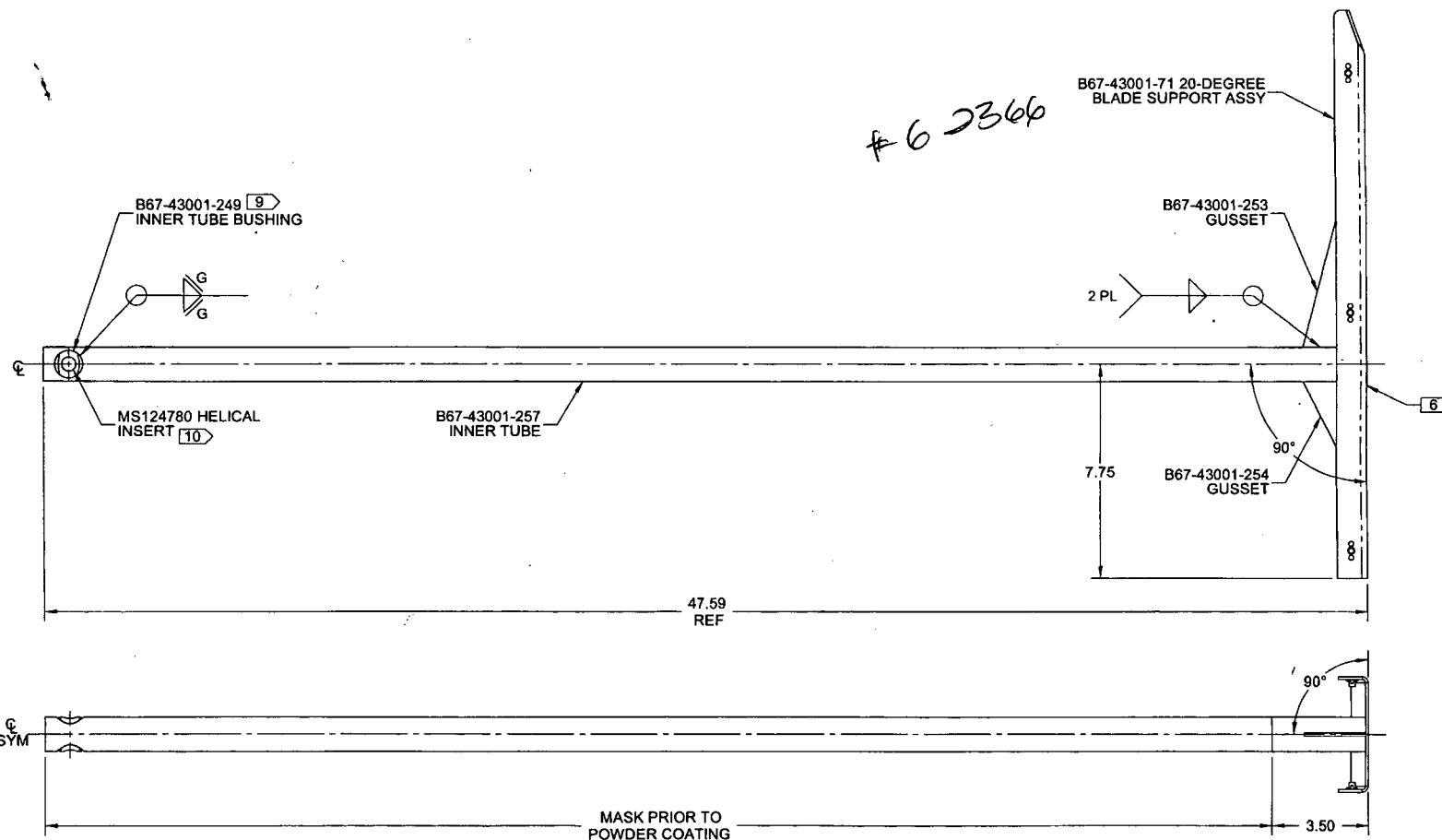
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16

- NOTES:**

 - 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-15W" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 3.35 lbs
 - 8) WELDING: PER QSI 004
 - 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
 - 10) INSTALL HELICAL INSERT PER MS33537

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>TJ</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MA</i>	B67-43001-15W	SHEET 2 OF 2
APPROVED	<i>JMP</i>	TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT WELDMENT NTS	
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